

Date: Tuesday, 22/07/2008 11:27:04 AM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001- Dart Helicopters Services	Drawing Name	: FRONT RAIL, LH
Job Number	: 40708		
Estimate Number	: 13492		
P.O. Number	:	Part Number	: D37661
This Issue	: 22/07/2008 S.O. No. :	Drawing Number	: D3766 REV B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: // Type : SMALL /MED FAB	Drawing Revision	: B
Previous Run	:	Material	:
Written By	:	Due Date	: 10/08/2008 Qty: 2 Um: Each
Checked & Approved By	: <u>JUL 08.7.22</u>		
Comment	: Est Rev:A 08-07-21 revB as per dwg DD verified by:EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6T1000W188	6061T6 RD TUBE 1.00 X .188W
Comment: Qty.: 2.9323 f(s)/Unit Total : 5.8647 f(s) 6061T6 RD TUBE 1.00 X .188W batch: <u>M104480</u> FF 08-07-23		
2.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
Comment: SMALL & MEDIUM FAB RESOURCE 1 1-cut tube to lenght as per dwg D3766 FF 08-07-23 2-drill holes thru.to finish size as per dwg D3766 FF 08-08-08 3- deburr FF 08-08-11		
3.0	QC5	INSPECT WORK TO CURRENT STEP
Comment: INSPECT WORK TO CURRENT STEP 8/8/11 (x2.5K)		
4.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1 08/08/11		
5.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION 08-08-11 (x7)		

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



(2x)

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: S13

8/8/11

SP

7.0

QC21

FINAL INSPECTION/W/O RELEASE



(2)

Comment: FINAL INSPECTION/W/O RELEASE

2008/08/12

Job Completion



MF 08-08-11

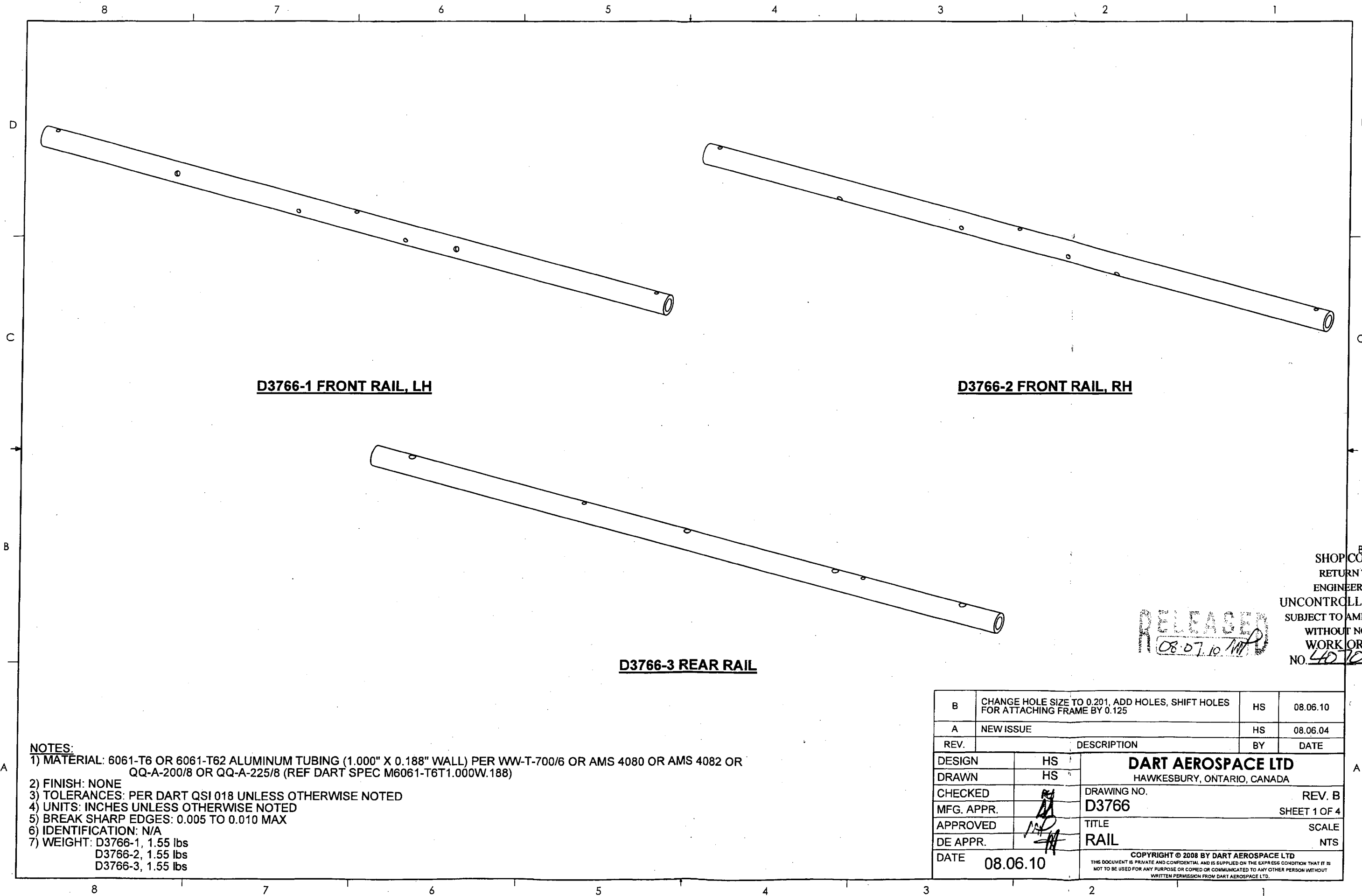
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3766-1 FRONT RAIL, LH

D3766-2 FRONT RAIL, RH

D3766-3 REAR RAIL

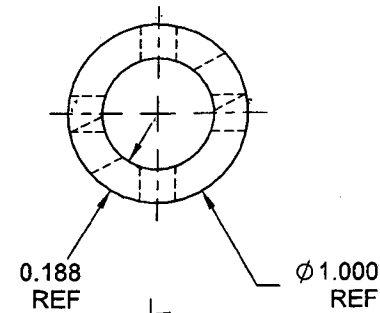
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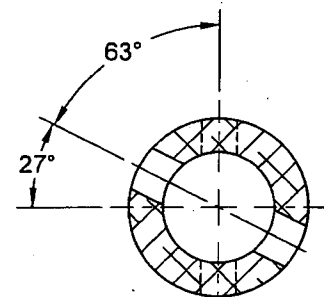
NOTES:

- 1) MATERIAL: 6061-T6 OR 6061-T62 ALUMINUM TUBING (1.000" X 0.188" WALL) PER WW-T-700/6 OR AMS 4080 OR AMS 4082 OR QQ-A-200/8 OR QQ-A-225/8 (REF DART SPEC M6061-T6T1.000W.188)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D3766-1, 1.55 lbs
D3766-2, 1.55 lbs
D3766-3, 1.55 lbs

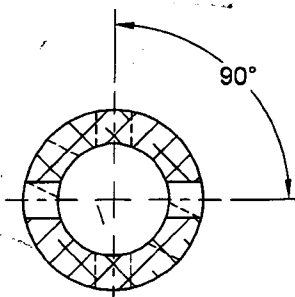
B	CHANGE HOLE SIZE TO 0.201, ADD HOLES, SHIFT HOLES FOR ATTACHING FRAME BY 0.125	HS	08.06.10
A	NEW ISSUE	HS	08.06.04
REV.	DESCRIPTION	BY	DATE
DESIGN	HS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	HS		
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3766	SHEET 1 OF 4
APPROVED		TITLE	SCALE
DE APPR.		RAIL	NTS
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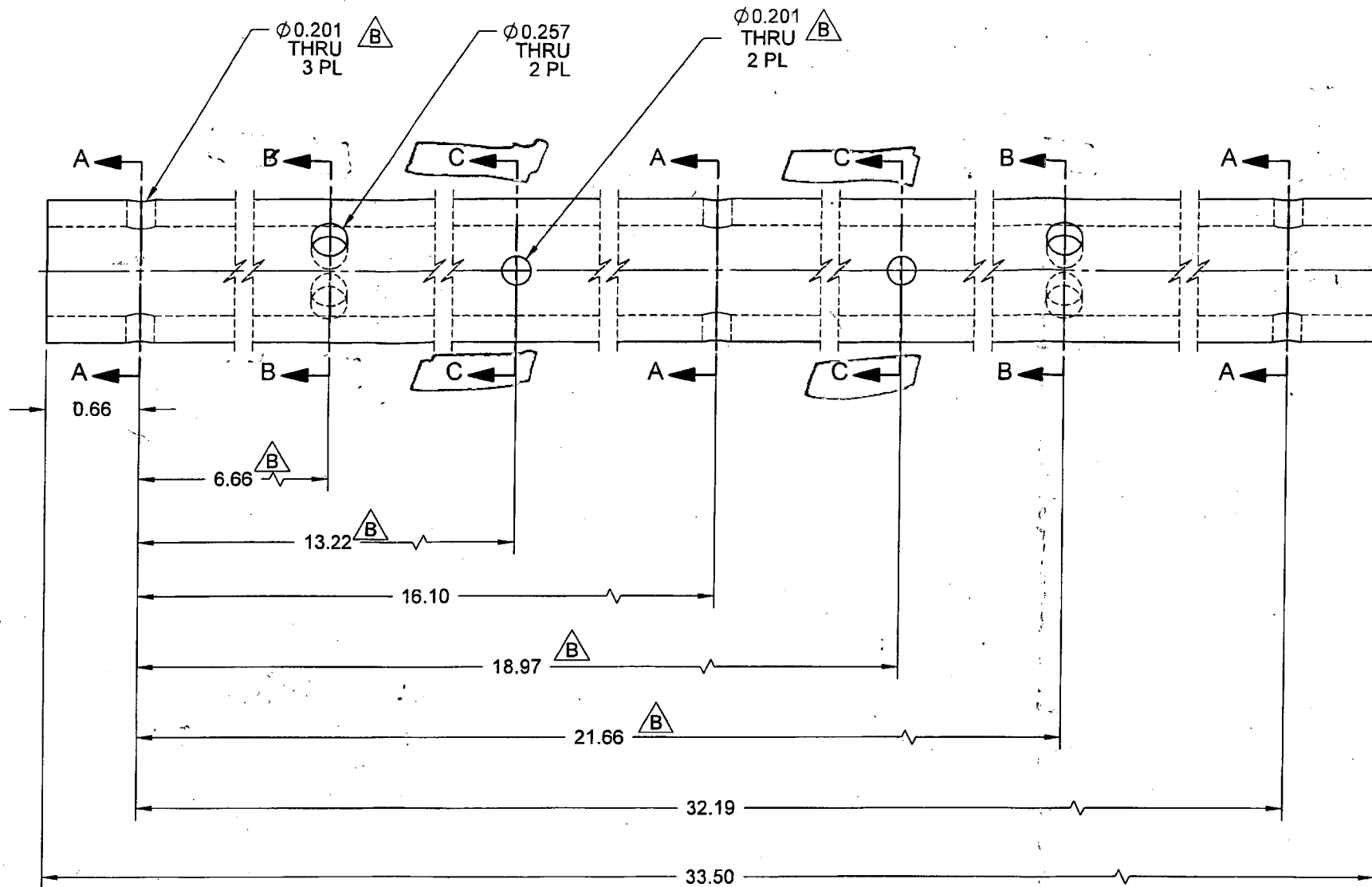
SECTION A-A



SECTION B-B







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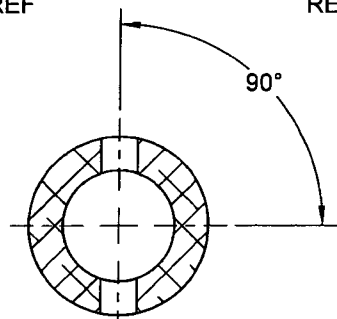
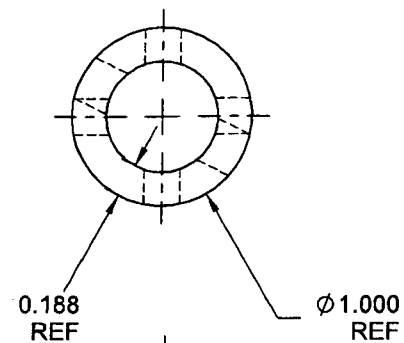


D3766-1 FRONT RAIL, LH

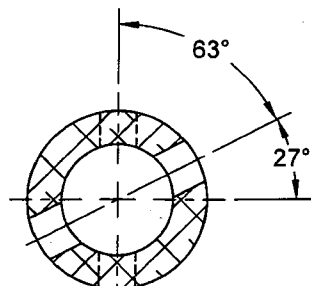
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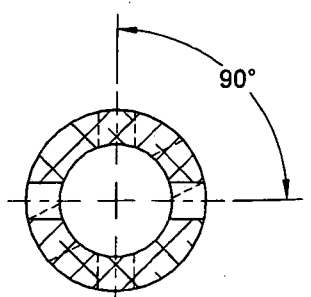
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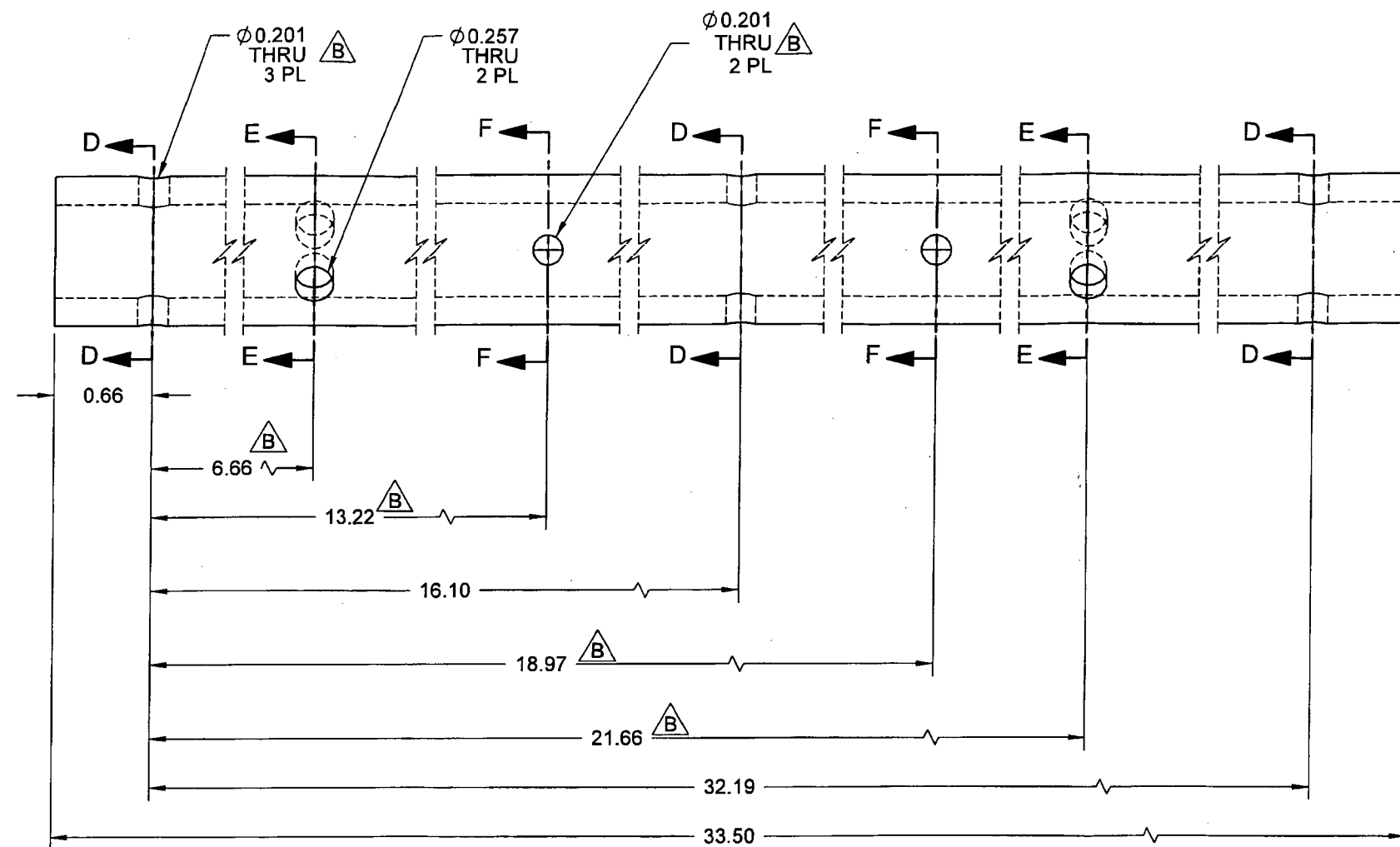
SECTION D-D



SECTION E-E



SECTION F-F



D3766-2 FRONT RAIL, RH

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0.188
REF

Ø 1.000
REF

Ø 0.323
THRU
4 PL

Ø 0.201
THRU
2 PL

D3766-3 REAR RAIL

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